

Date: Thursday, 30/10/2008 1:45:49 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Service		Drawing Name	: VERTICAL TUNNEL AFT CENTER		
Job Number	: 43098		Part Number	: D38223		
Estimate Number	: 13587		Drawing Number	: D38223 UNDER REVIEW → 08/11/10		
P.O. Number	:		Project Number	: IN0002		
This Issue	: 30/10/2008 S.O. No. :		Drawing Revision	: A UNDER REVIEW		
Prsht Rev.	: NC		Material	: MKYDEX6185S80P362015		
First Issue	: / / Type : R&D THERMOFORMING		Due Date	: 06/11/2008 Qty: 2 Um: Each		
Previous Run	: 42069					
Written By	:					
Checked & Approved By	:					
Comment	: Est. A New Issue 08/09/17 DL					

PROTOTYPE

PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

30/10/2008 JH

POSITIVE
RECALL
Cancel JH ✓

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MKYDEX6185S80P362015 Kydex velour matte, ivory



Comment: Qty.: 5.4170 sf(s)/Unit Total : 10.8340 sf(s)

Kydex velour matte, ivory

M-109703

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

08/11/03 Wh

3.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

08/11/03 Wh

4.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

X2

Thermoform as per Dwg. D3822-3and folio (FTA 9072 Prototype) using tool DT 9072

Dwg. Rev. A UNDER REVIEW.

Folio Rev. A -

08/11/03 Wh

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



X2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

08/11/03 Wh

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 30/10/2008 1:45:49 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL AFT CENTER

Job Number: 43098

Part Number: D38223

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8

SECOND CHECK



JFB

08/11/16.



X2

Comment: SECOND CHECK

7.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

8.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

APPROVAL *PP 08.12.01*

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.12.01 Prototype

Job Completion



W08.12.21 POSITIVE RECALL

~~EFFECTIVE 08.12.01 AUTH U~~
~~RELEASED _____ DATE _____~~

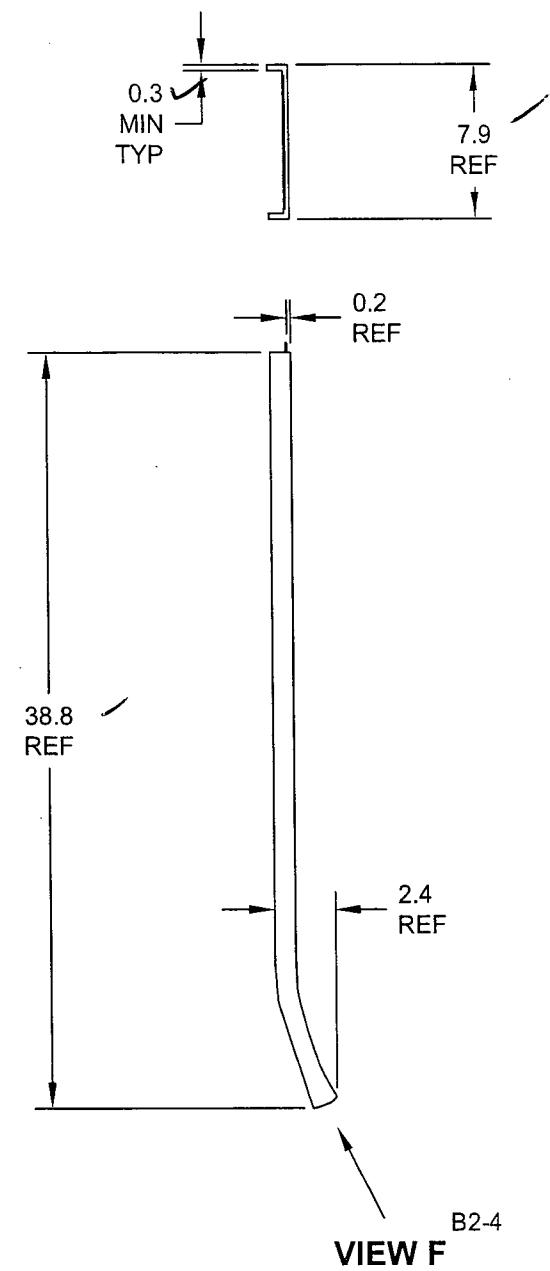
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

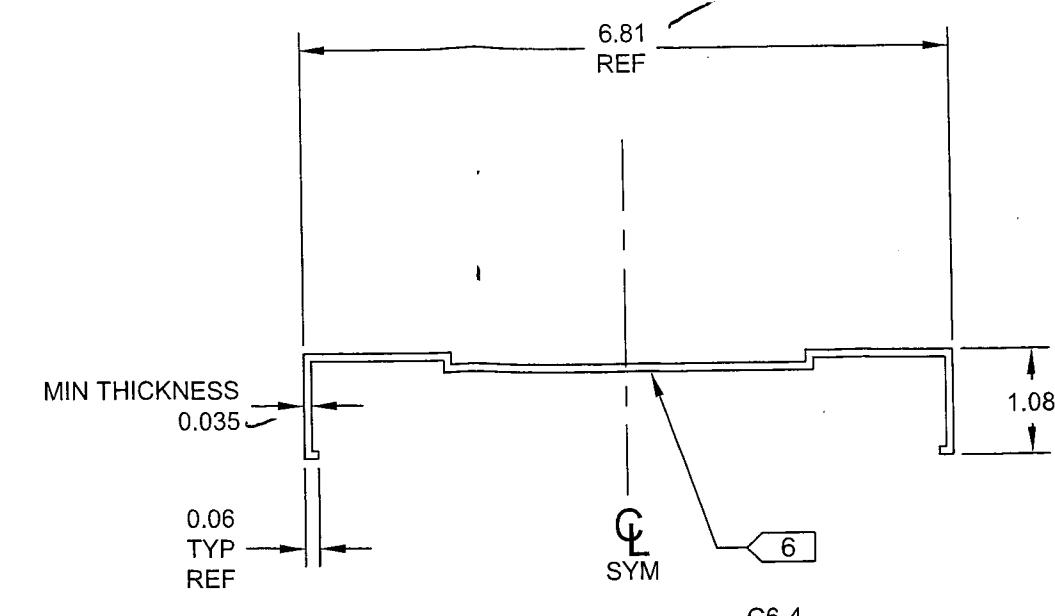
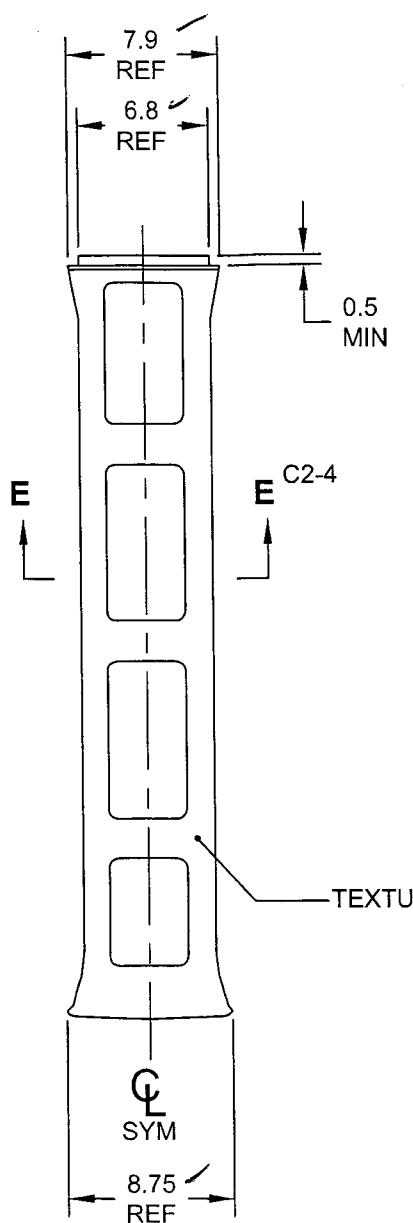
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

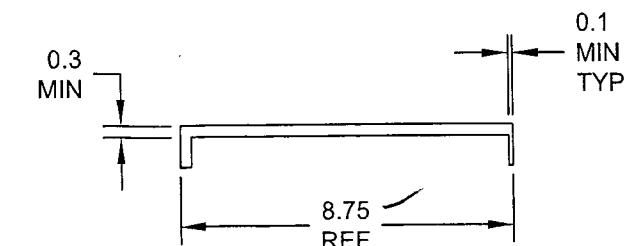


VIEW F

D3822-3 VERTICAL TUNNEL, AFT CENTER



SECTION E-E
SCALE 5X



VIEW F
SCALE 2X
(ROTATED 90° CW)

PROTOTYPE
PBT
08.11.10

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3822-3" USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD

DESIGN	PBT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	PBT	
CHECKED		DRAWING NO.
MFG. APPR.		REV. A
APPROVED		SHEET 4 OF 6
DE APPR.		TITLE
DATE	08.09.24	SCALE
		VERTICAL TUNNEL
		NTS

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Receiving Report

Date: 8/10/04

Batch No: M109703

Supplier: SABRC

Dart P/O: 7280

Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr

Release Note Attached: Yes No N/A
 Waybill Attached: Yes No
 Shipment Complete: Yes No N/A
 QC6 Inspection: OK N/A
 Work Order: OK N/A

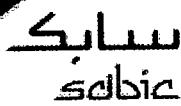
Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Admin: _____

Location: _____



SABIC Polymershapes

250 OLD INNES RD. 519 OTTAWA,ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM #: 1

QUANTITY: 51

54 *Sab* /27

S
08|0|27

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS
OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE
PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND
LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL
BRANCH MANAGER

DART AEROSPACE LTD	Work Order:	43098
Description: Vertical Tunnel Aft Center/prototype.	Part Number:	D3822-3
Inspection Dwg: D3822 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "				
Shape Definition	/			
Texture Retention	/			
Material imperfections such as bumps, cracks, voids, scratching	/			

Measured by: PB

Date: 08/11/27

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.3	min	0.310	/			
7.9 (Ref)		7.91	/			
0.2 (Ref)		0.2	/			
38.8 (Ref)		38.8	/			
2.4 (Ref)		2.5	/			
7.9 (Ref)		7.91	/			
6.8 (Ref)		6.8	/			
0.5	min	0.5	/			
8.75 (Ref)		8.75	/			
6.81 (Ref)		6.81	/			
1.08	+/- 0.030	1.08	/			
0.035	min	0.037	/			

Measured by: PB

Date: 08/11/27

Audited by: PB

Date: 08-11-27

Prototype Approval: PB

Date: 08-12-01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	